Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2017-14 **Date Opened:** 16 Jan 17 **Title:** Fabrication

Aircraft OEM: Multiple **Aircraft Model:** Multiple **Product Type:** Handle Lever Assembly **Product Model:** Multiple **Quantity:** 12 L, 11 R

Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	DM
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JC
Parts Distribution Sheet	N/A
Sub Component Tags	N/A
Completed Certification (Original)	N/A
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

	Initial or N/A
Tasks Initialled	JC
Dual Inspections Initialled	N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
84261	2	Handle Bar Assembly	JC
84265	2	Handle Lever	JC
36274	3	Handle Bushing	JC

Traveller

	Initial or N/A
Weld bushing to lever	DM
Weld rivet to lever	DM
Drill bushing to size "O"	DM

Component Completion

	As Instructed
Quantity Complete on This Work Order	12 L/11 R
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	JC
Release to Stock as Components	JC

Certification

	Initial or N/A
Form One Completed	N/A
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	JC
Unserviceable (Red) Tag Completed	N/A
Parts Placed in Stores for Distribution	N/A

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

	Initial or N/A
Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Work performed by: Print: David Martyn Sign: David Martyn SCA: AD05 Date: 16-Jan-17

ICC / Dual Inspection preformed by: Print: Jeff Clarke Sign: Jeff Clarke SCA: ~~AD01~~ AD02 JC Date: 17-Jan-17

Work Order closed by: Print: Jeff Clarke Sign: Jeff Clarke SCA: AD01 AD02 JC Date: 17-Jan-17

BASKET HANDLE – LEVER ASSEMBLY – 84261-02

General

These instructions apply to the end bracket used for the handle assembly used on cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

36274, Revision 3 – Handle Bushing
84261, Revision 2 – Handle Assembly

Work Order: 2017-14 Batch Quantity: 23

Date Open: Jan 2017

Complete (initial or SCA #)

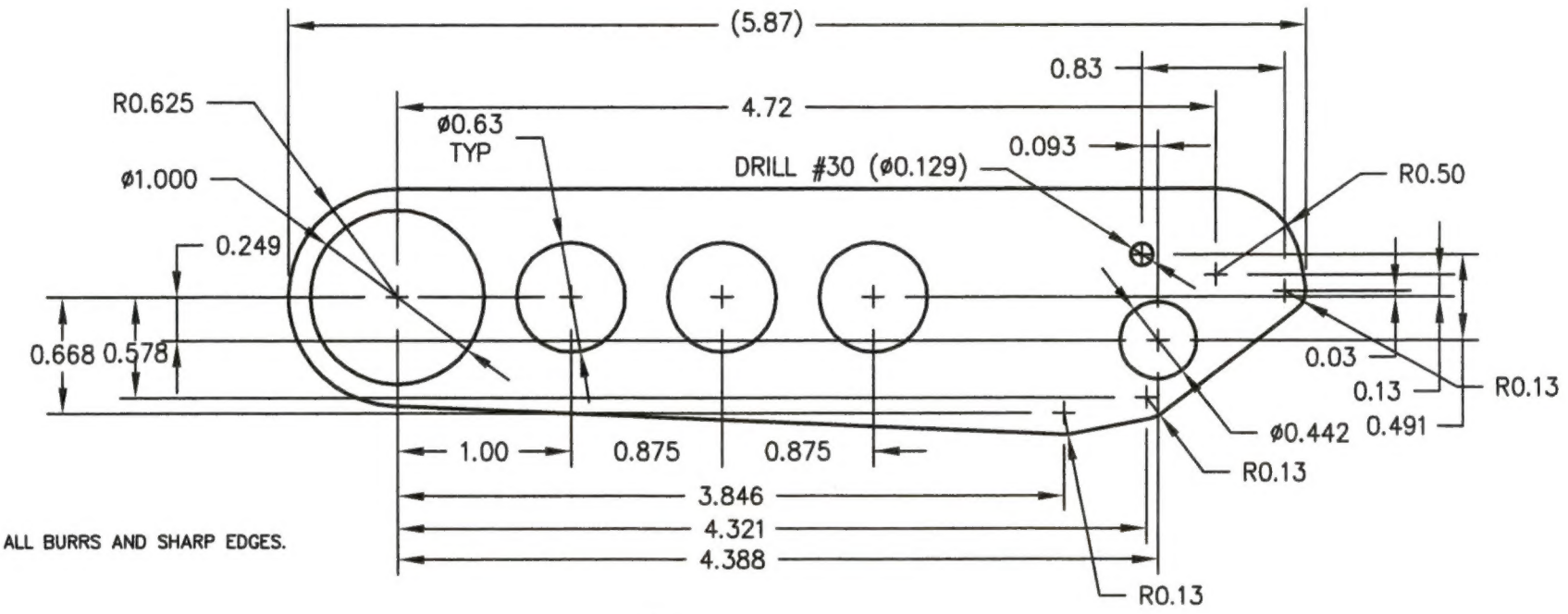
1. 36274-01 Bushing - Cut stock material: AD 73-04 05
 a. Cut 7/16" x 0.065" wall stainless steel tube to 0.75" length.
 b. Record material PO: PO: 14103
 c. De-burr cut ends.
 d. Tag in-progress parts and place on in-progress shelf in machine shop for turning to length. AD 73-04 05

2. 36274-01 Bushing - Turn stock material
 a. Grip tube in collet with a stop inside the collet.
 b. Turn face flat, just enough to remove cut marks, 0.020 max. Turn at 1030 RPM, at 0.010"/rev feed. Deburr outside and inside. Repeat for entire batch.
 c. Insert faced end of tube into collet against stop. Turn to finished length of 0.700" at 1030 RPM, at 0.010"/rev feed. Multiple passes may be required to minimize burr. Deburr outside and inside. Repeat for entire batch.
 d. Tag in-progress parts and place on in-progress shelf in machine shop for welding. AD 73-04 05

3. 84261-02 Lever Assembly
 a. Record material POs:
 i. 84265-01 Lever (0.125" stainless steel, laser cut): PO: 15018(3)/16072(20)
 ii. MS20615-4M3 Monel Rivet PO: 13026
 iii. ER308L Welding rod PO: 14028
 b. Use jig (??) to set the components at the required depths.
 i. Insert MS20615-4M3 monel rivet into small recess, head down
 ii. Insert 36274-01 Bushing into hole
 iii. Set 84265-01 Lever over bushing and rivet on jig, tap into place if required.
 iv. Weld tail of rivet and around bushing on top side only.
 v. Make equal quantities of left and right parts.
 c. Tag in-progress parts and place on in-progress shelf in welding shop for cleanup. AD 73-04 05

4. Clean up
 a. Media blast completed lever assemblies to remove discolouration around welds and to leave a consistent finish on entire part. Blow off thoroughly after blasting.
 b. Drill through bushing on lathe using O (0.316") drill at 300 RPM. Grab bushing with chuck, ensure rivet is seated between jaws. Ensure drill is sharp. De-burr if required.
 c. Tag finished parts and place on in-progress shelf in welding shop for assembly with handle.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	REMOVE TOOLING HOLES, ADD LIGHTENING HOLES	BJC	18/06/2010
2	TITLE BLOCK UPDATED, ADD ALTERNATE MATERIAL	BJC	13/03/2014



NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.

(01) LEVER

PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
	01	(ALTERNATE MATERIAL)	AISI 304 STAINLESS	AMS 5513	0.125" SHEET
84265-01	01	LEVER	AISI 304 STAINLESS	AMS 5513	0.100" SHEET

LIST OF MATERIALS

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APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS		ANGLES
X.XXX	±0.010	±1/2°
X.XX	±0.03	
X.X	±0.1	

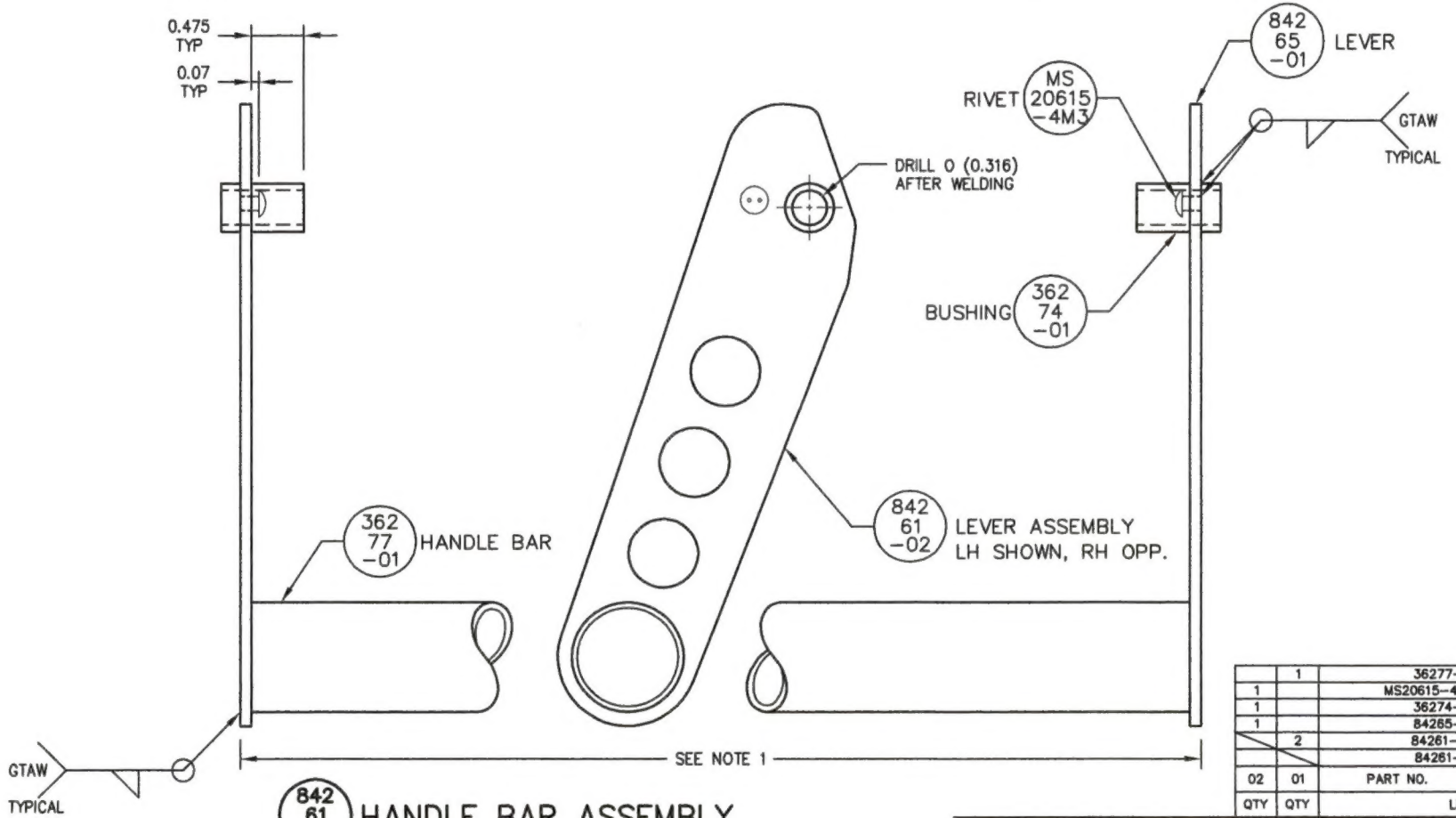
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HELICOPTER CARGO BASKET HANDLE LEVER

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84265	2

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



842 61 -01 HANDLE BAR ASSEMBLY

NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

	1	36277-01	HANDLE BAR
1		MS20615-4M3	RIVET (MONEL)
1		36274-01	BUSHING
1		84265-01	LEVER
	2	84261-02	LEVER ASSEMBLY (RH/LH)
		84261-01	HANDLE BAR ASSY
02	01	PART NO.	DESCRIPTION
QTY	QTY	LIST OF MATERIALS	

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

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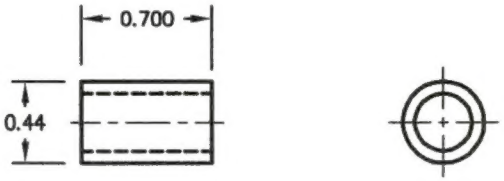
HELICOPTER CARGO BASKET
HANDLE BAR ASSEMBLY

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84261	2

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE – CREATED FROM 36210	STF	MAY 17/02
1	REMOVE ALTERNATE PART, REMOVE STEP FROM BUSHING	BJC	JAN 8/07
2	LENGTH CHANGED	BJC	NOV 03/09
3	TITLE BLOCK UPDATE, ADD ALTERNATE MATERIAL	BJC	MAR 13/14

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.



(01) BUSHING

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
		01	(ALTERNATE MATERIAL)	316 STAINLESS STEEL	ASTM A269	7/16" X 0.065" TUBE
	36274-01	01	BUSHING	304 STAINLESS STEEL	ASTM A269	7/16" X 0.065" TUBE

LIST OF MATERIALS

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APPROVALS	DATE
DRAWN: STEVEN FAHEY	MAY 17/02
CHECKED: E. BURGOIN	MAY 01/03

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

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HELICOPTER CARGO BASKET HANDLE LEVER BUSHING

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.	
SHEET 1 OF 1	A4	36274	3	